

Date: Friday, 15/02/2008 9:21:10 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING ASSEMBLY		
Job Number	: 37470		Part Number	: D3121241		
Estimate Number	: 10716		Drawing Number	: D3121 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/02/2008		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 22/02/2008		
Previous Run	: 36669		Qty:	13		
Written By	:		Um:	Each		
Checked & Approved By	:					
Comment	: Est Rev:A 04/02/18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
		Comment: Qty.: 0.0546 f(s)/Unit Total : 0.7098 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) Identify as D3121-25 Batch: <u>8F 08/02/15</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	D312123	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 13.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing <u>36670</u>	

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Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

8.F 05/02/15 (13)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13 08/02/15 (13)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 36663

8.F 05/02/15

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

13 08/03/04

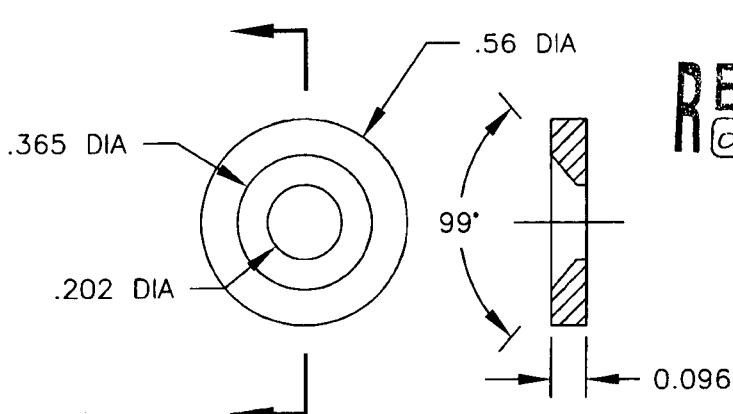
Job Completion



13 2008/3/04 (13)

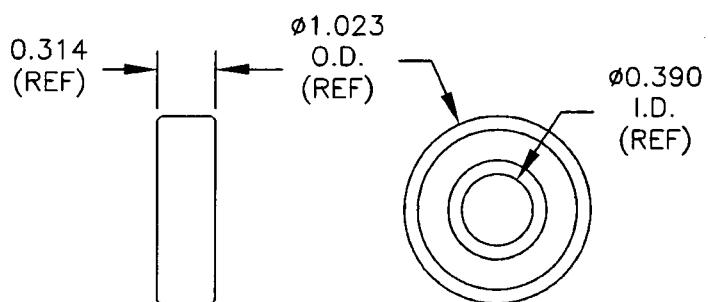
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D3121	REV. E
DATE		TITLE	SHEET 10 OF 10
07.11.07		BRACKET ASSEMBLY	1:1



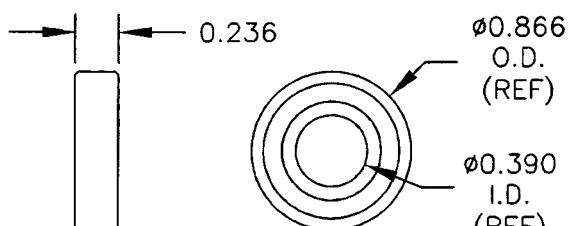
#### D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



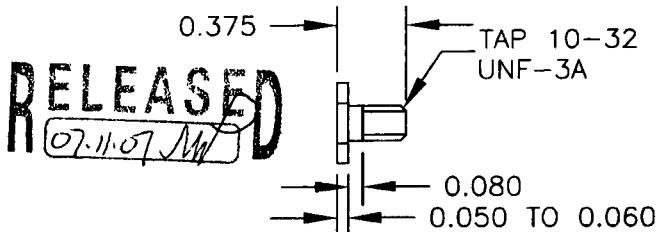
#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



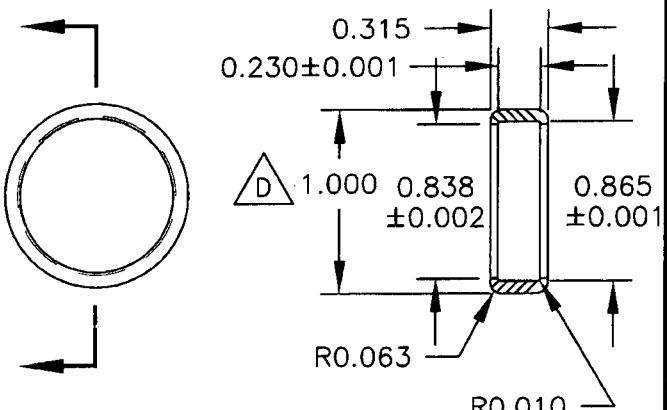
#### D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



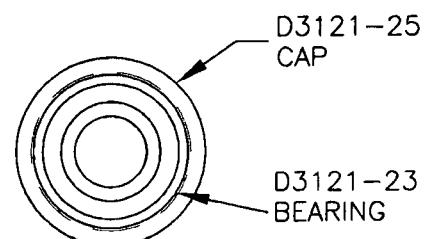
#### D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



#### D3121-241 BEARING ASSEMBLY (SCALE 1:1)